

5/06

DART AEROSPACE LTD	Work Order:	22122
Description: End Plate	Part Number:	D3067-1
Drawing: D3067 Rev. A	Qty:	166 160
		Page 1 of 1

RF 02/10/17 Stack of 8

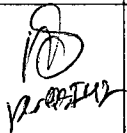
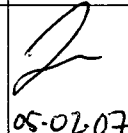
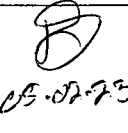
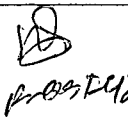
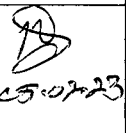
Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller	RF	05.01.03	160
2	MV	Cut blanks 2.750" x 3.030" +/- 0.005 Grain along 2.750" Material: 5052-H32 (QQ-A-250/8) (M5052H32S.063) or 6061-T6 (QQ-A-250/11) (Ref. M6061T6S.063) Batch: M16455 CPL		05-01-18	167
3	MV	Machine per folio FA183 and Dwg D3067	SP	05.01.19	167
4	QC2	Inspect parts as they come off the CNC machine	SP	05.01.19	167
5	QC7	Second inspection	RF	05.01.19	167
6	MV	Deburr			
7	GB	Bend as per Dwg D3067	2	05.02.07	166
8	QC5	Inspect work to Step 7	PD	05.02.22	166
9	WA	Identify and stock	PD	05.02.22	166
10	AC	Cost / Part 1.22	Sur	05.02.23	166
11	DC	Close W/O 1, 13 Inspect level 21	RF	05.02.28	166


P50

Rev	Date	Change	Revised By	Approved
A	01.12.10	New Issue	EC	
B	02.01.03	Now machined on HAAS	SM	
C	02.10.04	Re-format	KJ RF	
C1	03.01.21	Remove step 6 (Deburr)	RF	

RELEASED
02/10/15 RF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR: 3067-1		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05-02-07	7	over bent first piece to 45° instead of 35°		destroy	 05-02-07	 05-02-23	 05-02-23	 05-02-23

Part No: D3067-1 PAR #: _____ Fault Category: mmuf/knabe NCR: ☒ Yes ☐ No DQA:  Date: 05/02/24

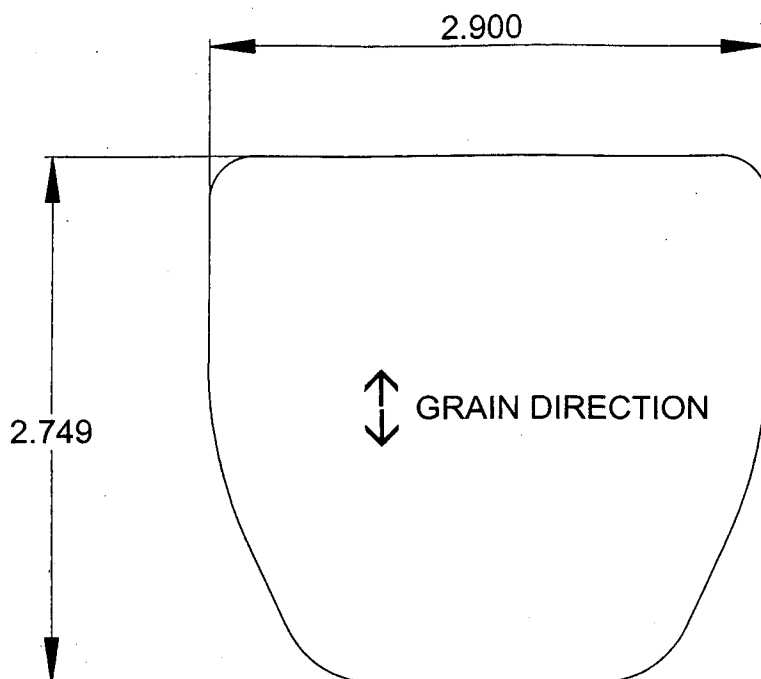
NOTE: Date & initial all entries

QA: N/C Closed:  Date: 05.02.28

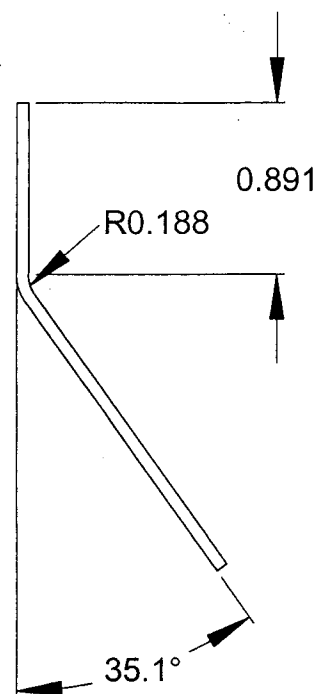


DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3067	REV. A SHEET 1 OF 1
DATE 02.09.11		TITLE END PLATE	SCALE 1:1
A	02.09.11	NEW ISSUE	

RELEASED
02.09.2011



D3067-1 FLAT PATTERN



D3067-1 BEND DETAIL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER

NO. 22122

D3067-1 END PLATE

- 1) MACHINE PER DWG FILE "D3067-1.SLDPRJT"
- 2) MATERIAL: 5052-H32 PER QQ-A-250/8 (REF DART SPEC. M5052H32S.063)
OR 6061-T6 PER QQ-A-250/11 (REF DART SPEC. M6061T6S.063)
ALUMINUM SHEET, 0.063 THICK
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Dec 20, 2004
09:28 am

Work Order No : 0022122
Project Name : D3067-1
Project For : WK506
Work Order Type : Main
Main WO Number :
House Part Number : D3067-1
Description : End Plate
Manufactured : Yes
Amount Req'd : 160
Amount Done : 0
Start Date : 12-20-04
Est Finish Date : 02-10-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00